

Work Order ID 135884

135884

Page 1

Monday, August 24, 2015 9:21:37 AM

Item ID: D119-796-151 Accept *N900040100* Setup Start *NS1*
 Revision ID:
 Item Name: FWD Crosstube Installation with Step (no hardware) Stop *NS2*
 Start Date: 8/24/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/24/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLS Date: AUG 24 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-151	D								

110 Document Control 0.00
 110
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and create labels as per PPP D119-796-151 chg 003
MLS JAN 14 2016

120 Pick Kit 0.00
 120 Packaging x-tube 134945
 Packaging Memo 0.00
 Packaging
 DAS 41 9-89
 16-1-13

130 Crosstubes 0.00
 130 Crosstubes
 Crosstubes Memo 0.01
 Crosstubes 1- Install step and clamp with the proper position per dwg D119-796-151
 Torque all clamps to 50 IN-LBS max.
 DAS 41 9-89
 16-1-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

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Item ID: D119-796-151 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: FWD Crosstube Installation with Step (no hardware)
 Start Date: 8/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89 JAN 14 2016
140									
QC	Memo	0.00							
Quality Control	***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***								
150		0.00							DAS 41 9-89
150	Packaging					1			16-1-14
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-151								
	For final assembly								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							ML5 JAN 14 2016
Quality Control									

ML5 JAN 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

Monday, August 24, 2015 9:21:41 AM

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Work Order ID: 135884

135884

Parent Item: D119-796-151

D119-796-151

Parent Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 8/24/2015

Required Date: 8/24/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C
14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:D 15-02-11
AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-141		Manufactured	No				Each	0.0000		1		DAS 41	
D119-796-141					134945				**	1		9-89	16-1-13
FWD Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	72.0000		4		DAS 41	
D5123-3									**			9-89	16-1-13
Clamp Cushion													
					137701					4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG055			49						
					133460		13						
					133959		30						
					134437		6						
				Ig55			23						
					126747		12						
					127133		6						
					131871		5						
D5149-041		Manufactured	No				Each	5.0000		2		DAS 41	
D5149-041									**			9-89	16-1-13
Fwd Step Base Assembly													
					137758					2			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG051			3						
					130000		1						
					134500		2						
				LG055			2						
					131413		2						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Work Order ID: 135884

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Parent Item: D119-796-151

D119-796-151

Parent Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 8/24/2015

Required Date: 8/24/2015

Start Qty: 1.00

Required Qty: 1.00

MS21920-22

Purchased

No

Each

108.0000

4

DAS

MS21920-22

41
9-89

16-1-13

Clamp

133483

4

Location

Loc Qty

Loc Code

LG050

108

M128636

3

M130822

2

M132045

4

M132275

4

M132550

45

M132854

50

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

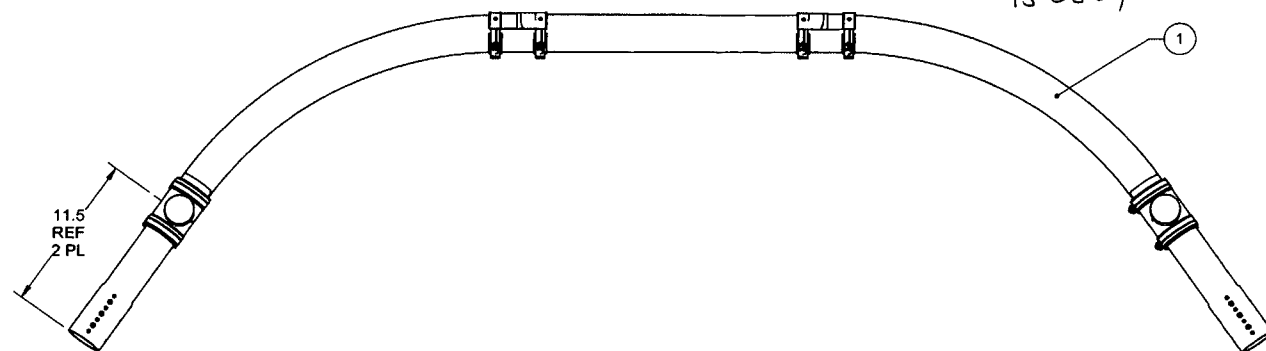
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

△

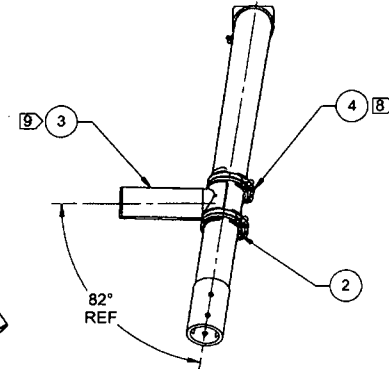
△

COPY
 RETURN TO
 ORDERING
 CONTROLLED COPY
 AMENDMENT
 NOTICE
 ORDER
 135884-MLJ
 15-0824



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

D119-796-141 XTUBE
BENDING PLANE



RELEASED

2015 FEB 09

ECN 15-516

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 19.87 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

△

D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	JLM	D119-796-151	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED